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(54) Title of Utility Model: Honeycomb-Shaped Filter Element
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Specification

1. Title of the Utility Model

Honeycomb-Shaped Filter Element

2. Claims

A honeycomb-shaped filter element, wherein a flat filter member and an undulating filter member are wound around a center pipe in scroll-like fashion, the obverse surface of both filter materials bonded together by the application of a sealing adhesive along the edges of the undulating filter member and the application of an adhesive at several places along the ridge lines of the various crest portions, and the reverse surface of both filter materials bonded together by the application of a sealing adhesive along the edges of the undulating filter member and the application of an adhesive at several places along the ridge lines of the various trough portions, and wherein the interval between the bonding positions along the ridge lines of the crest portions and trough portions of the obverse surface and reverse surface of the filter materials ranges between 20 mm and 30 mm.

3. Detailed Description of the Utility Model

(Industrial Field of Application)

The present utility model relates to a honeycomb-shaped filter element used primarily in air filters in which a flat filter member and an undulating filter member are wound around a center pipe in scroll-like fashion.

(Prior Art)

Honeycomb-shaped filter elements (e) usually consist of a flat filter member and an undulating filter member made out of filter paper. The construction method will now be summarized with reference to FIG 4 (a) and FIG 4 (b). First, as shown in FIG 4 (a), the flat filter member 1 and the undulating filter member 2 are arranged so that they face each other, and one edge of the surface of the undulating filter member 2 facing the other member (the obverse surface) is filled with a sealing adhesive 3 (such as a vinyl chloride-based adhesive) using an adhesive gun. At the same time, spots of a quickly drying adhesive 4 (such as a vinyl acetate-based adhesive) are applied along the ridge of the crest portions excluding the sealed portion as the members 1, 2 are rolled up. Next, as shown in FIG 4 (b), one edge of the bonded undulating filter member 2 on the surface opposite the one described above (the reverse surface) is filled with a sealing adhesive 3, and spots of a quickly drying adhesive 4 are applied along the ridge of the trough portions excluding the sealed portion. The integrated filter element is wound in scroll-like fashion around a center pipe 5 with one edge of the undulating filter member being sealed.

A filter element (e) is thus formed in which one edge is sealed with a sealing adhesive 3 leaving a plurality of channels open on the other side widthwise and in which both the obverse and reverse surfaces of the flat filter member 1 and the undulating filter member 2 are bonded to each other along the ridges of the crest portions.

In addition, a steel support ring 6 is placed on the top edge of the filter element (e) and another support ring 6 and elastic packing 7 are placed on the other

edge before being housed in a cup-shaped container (a) for use. A cover (b) is then attached, and the container (a) and the cover (b) are fastened by placing several clips (c) around the edge.

(Problem Solved by the Utility Model)

The obverse and reverse surfaces of the flat filter member 1 and undulating filter member 2 constituting the filter element are attached to each other by applying spots of adhesive at certain intervals along the ridge line of the crest and trough sections of the undulating filter member 2. Because the present interval in filter elements of the prior art is a relatively large 50 mm to 60 mm, the buckling strength of these filter elements is inadequate. When the element is placed inside the container (a), the cover (b) is attached, and the edges fastened using clips (c), the pressure applied to the periphery of the filter members causes the center to bulge laterally, the bonded portions to pull apart, and the filtering function to decrease.

However, when the bonded sections of the filter members 1, 2 are increased to strengthen the filter element, the effective filtering area of the filter members and the longevity of the filter are reduced.

The purpose of the present utility model is to provide a long-lasting filter element with high buckling strength by bonding both the obverse and reverse surfaces of the flat filter member and undulating filter member at the appropriate interval.

(Means of Solving the Problem)

The present utility model solves this problem by providing a honeycomb-shaped filter element, wherein a flat filter member and an undulating filter member are wound around a center pipe in scroll-like fashion, the obverse surface of both filter materials bonded together by the application of a sealing adhesive along

the edges of the undulating filter member and the application of an adhesive at several places along the ridge lines of the various crest portions, and the reverse surface of both filter materials bonded together by the application of a sealing adhesive along the edges of the undulating filter member and the application of an adhesive at several places along the ridge lines of the various trough portions, and wherein the interval between the bonding positions along the ridge lines of the crest portions and trough portions of the obverse surface and reverse surface of the filter materials ranges between 20 mm and 30 mm.

(Working Example)

FIG 1 and FIG 2 show a working example of the present utility model. A band-shaped flat filter member 11 and undulating filter member 12 are arranged so that they face each other, and edges of the obverse surface of the undulating filter member 12 (the surface facing the other member) are filled with a sealing adhesive 13 using an adhesive gun. At the same time, spots of a quickly drying adhesive 14 are applied at 20 mm to 30 mm intervals along the ridge of the crest portions excluding the sealed portion as the members are rolled up. The flat filter member 11 and the undulating filter member 12 are bonded to each other by the sealing adhesive 13 and the adhesive 14 applied along the ridge of the crest portions.

The edges of the reverse surface of the bonded undulating filter member 12 or the surface opposite the one shown in FIG 2 are then filled with a sealing adhesive 13, and spots of a quickly drying adhesive 14 are applied at 20 mm to 30 mm intervals along the ridge of the trough portions excluding the sealed portion. The integrated filter element is wound in scroll-like fashion around a center pipe 15 with one or both edges of the undulating filter member 12 sealed. The reverse surfaces of the flat filter member 11 and undulating filter member 12 are sealed by the sealing adhesive 13 and the adhesive 14 on the ridge line of the trough portion to form a rolled-up filter element (e) of a certain diameter.

A support ring is placed on one edge of the filter element (e) and either another support ring or elastic packing is placed on the other edge before being housed in a cup-shaped container.

FIG 3 is a graph showing the relationship of the interval between the bonding positions of the quick drying adhesive 14 on the obverse and reverse surfaces of the flat filter member 11 and the undulating filter 12 and the buckling strength and longevity of the element. Here, curve A denotes the buckling strength and curve B denotes longevity. As for the buckling strength of the element, the bonding position interval is inversely proportional to the strength. At intervals of 50 mm or less, there is a direct increase in strength. At 30 mm, the strength is 120 kg, while at 50 mm as in the prior art, the strength is 60 kg. In other words, the increase in strength is two fold. At 20 mm, the strength is 165 kg or 2.7 times the strength at 50 mm.

As for the longevity of the element, it sharply increases at intervals between 0 mm and 20 mm but rises only gradually between 20 mm and 50 mm. At intervals above 50 mm, the longevity of the element hardly changes at all.

The optimum value for the interval between bonding positions for the flat filter member 11 and the undulating filter member 12 was determined to range anywhere from 20 mm to 30 mm based on these consideration.

Therefore, in the present utility model, the interval between bonding positions for the flat filter member 11 and the undulating filter member 12 can be set anywhere between 20 mm and 30 mm.

(Effect of the Utility Model)

The present utility model provides a honeycomb-shaped filter element, wherein a flat filter member and an undulating filter member are wound around a center pipe in scroll-like fashion, the obverse surface of both filter materials bonded together by the application of a sealing adhesive along the edges of the undulating filter member and the application of an adhesive at several places along the ridge lines of the various crest portions, and the reverse surface of both filter materials bonded together by the application of a sealing adhesive along the edges of the undulating filter member and the application of an adhesive at several places along the ridge lines of the various trough portions, and wherein the interval between the bonding positions along the ridge lines of the crest portions and trough portions of the obverse surface and reverse surface of the filter materials ranges between 20 mm and 30 mm. As a result, the filter element has two to three times the buckling strength of filter elements of the prior art, and the element does not become warped in the middle, the bonded portions do not come apart, the filtering function does not decrease, and longevity is maintained even when placed inside a container, covered and fastened with clips. Therefore, the filter element is ideal for use in many different situations.

4. Brief Explanation of the Drawings

FIG 1 is a perspective view of the bonding of the flat filter member and the undulating filter member in the filter element of the present utility model. FIG 2 is a perspective view of the rolled-up filter element. FIG 3 is a graph of test results. FIG 4 (a) is a perspective view of the bonding of the flat filter member and the undulating filter member in a filter element of the prior art. FIG 4 (b) is a perspective view of a rolled-up filter element of the prior art. FIG 5 is a cross-sectional view of the filter element housed in its container.

1, 11 ... flat filter member

2, 12 ... undulating filter member
3, 13 ... sealing adhesive
4, 14 ... adhesive
5, 15 ... center pipe
e ... filter element

Applicant: **Tsuchiya Industrial Works, Ltd.**

Agent: **Shinichi SANADA, Patent Attorney**

FIG 1

11 ... flat filter member
12 ... undulating filter member
13 ... sealing adhesive
14 ... adhesive

FIG 2

11 ... flat filter member
12 ... undulating filter member
13 ... sealing adhesive
14 ... adhesive
15 ... center pipe
e ... filter element

FIG 3

[horizontal axis] Bonding Position Interval
[vertical axis] Buckling Strength

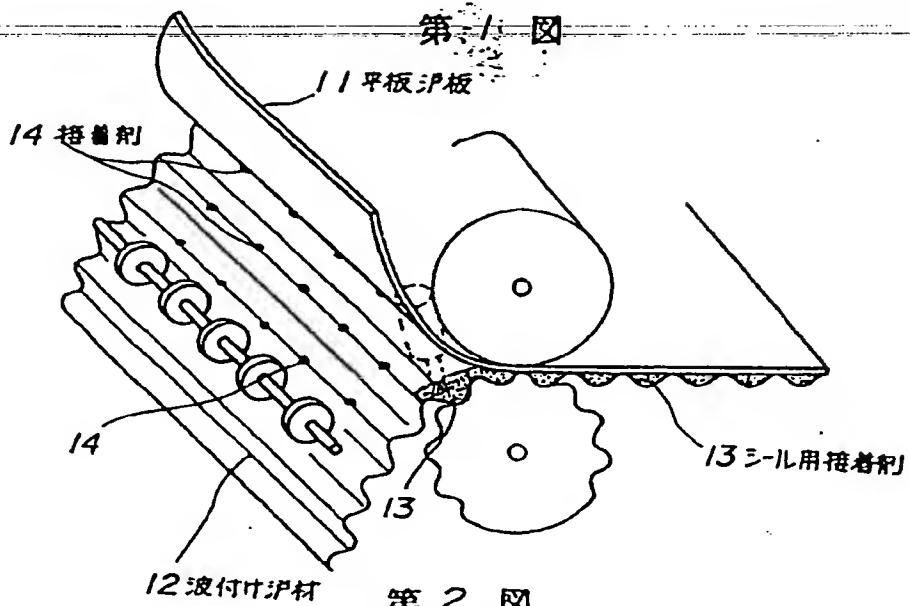
FIG 4

FIG 5

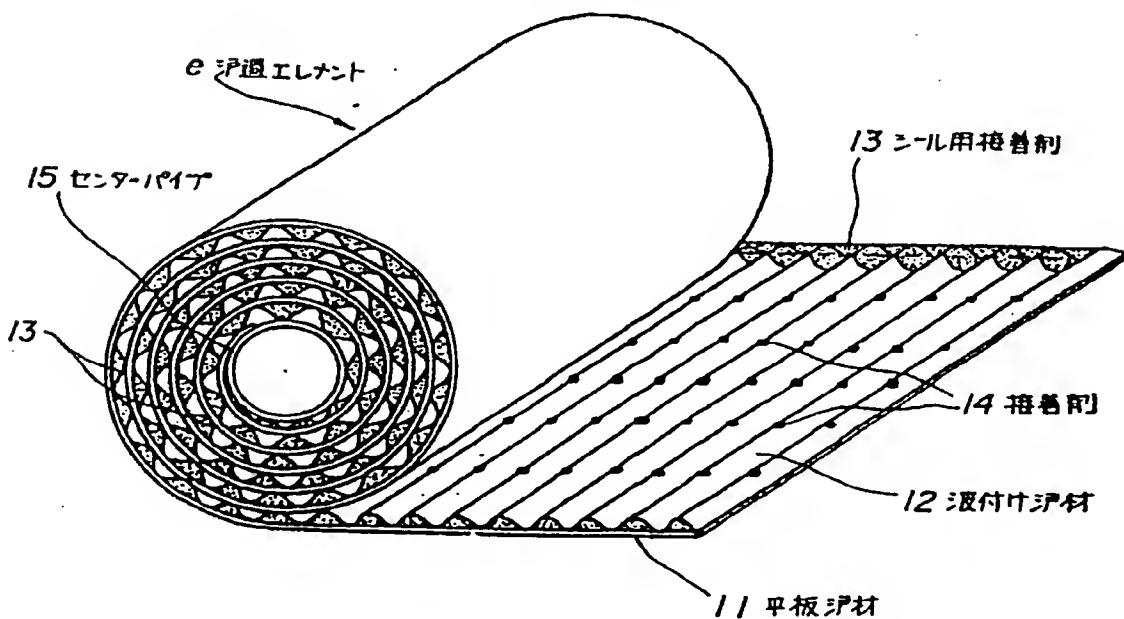
Applicant: Tsuchiya Industrial Works, Ltd.

Agent: Shinichi SANADA, Patent Attorney

第1図



第2図

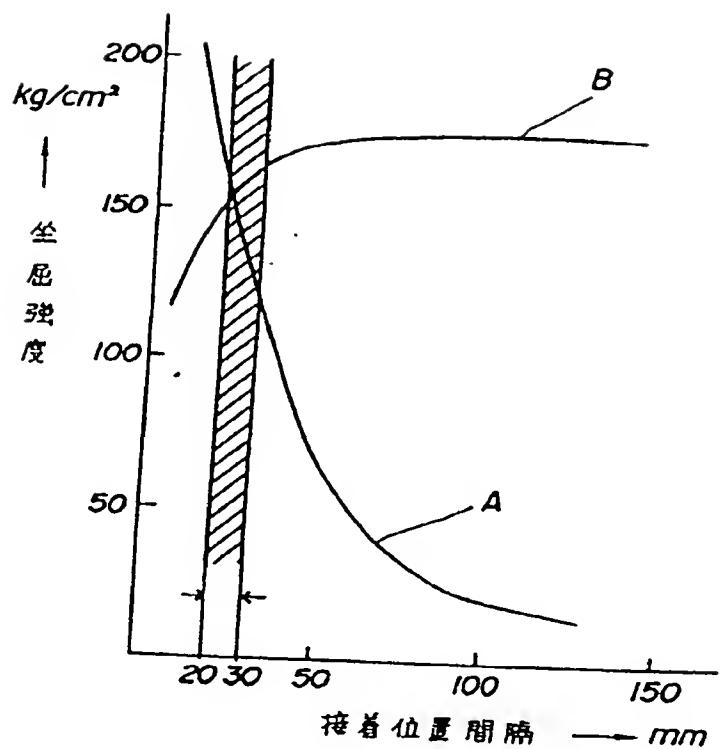


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第3図



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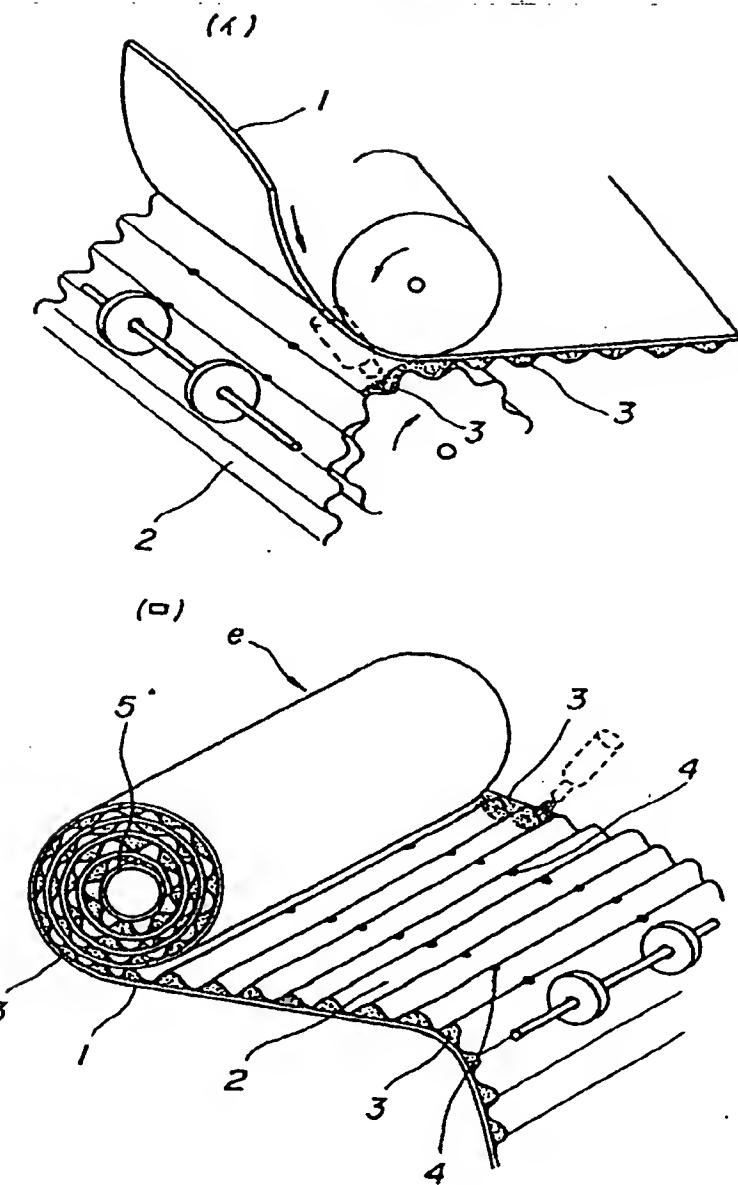
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第4図



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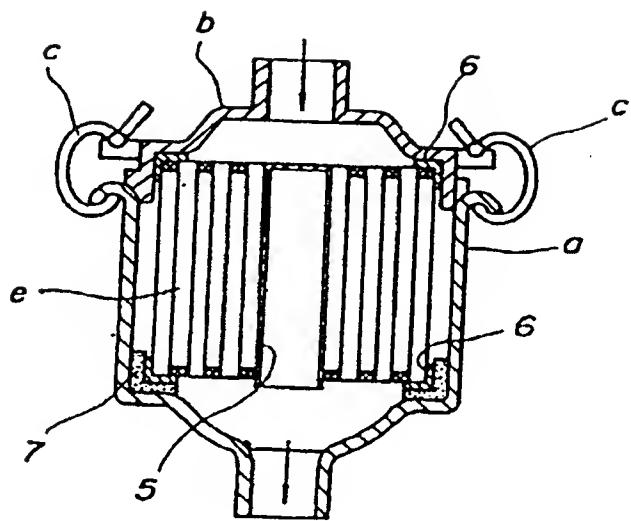
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第5図



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審査請求 未請求 (全頁)

⑤考案の名称 ハニカム形の戸過エレメント

⑥実願 昭62-11413

⑦出願 昭62(1987)1月30日

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明細書

1. 考案の名称

ハニカム形の戸過エレメント

2. 実用新案登録請求の範囲

平板戸材と波付け戸材からなつてセンターバイブ上にうず巻き状に巻回され、両戸材の表面同志は波付け戸材の一側側縁に施されたシール用の接着剤と波の各山部の稜線上の複数箇所に塗布された接着剤によつて接着され、また、裏面同志は波付け戸材の他側側縁に施されたシール用の接着剤と波の各谷部の稜線上の複数箇所に塗布された接着剤によつて一体に接合されるハニカム形の戸過エレメントにおいて、上記両戸材の表面および裏面における波の山部または谷部の稜線上の接着位置の間隔を 20mm ないし 30mm にしたことを特徴とするハニカム形の戸過エレメント。

3. 考案の詳細な説明

(産業上の利用分野)

この考案は平板戸材と波付け戸材とを重ね合



せてセンターバイプの回りにうず巻き状に巻き付けるいわゆるハニカム形の戸過エレメントに關し、主としてエアーフィルター用の戸過エレメントに関する。

(従来の技術)

一般にハニカム形の戸過エレメントは戸紙などの平板戸材と波付け戸材からなるが、その作り方の概略を示せば第4図イ、ロのとおりであり、先ずイ図のように平板戸材1と波付け戸材2とを向き合せ、波付け戸材1の向き合う面（両戸材とも表面という）の片側側縁にシール用の接着剤（塩化ビニル系のものなど）3を塗布ガスにより充填的に施すと共に波の山部稜線上に一定の間隔で速乾性の接着剤（醋酸ビニル系のものなど）4をのり付けロールでスポット的に塗布しつつ両戸材1、2を一体的に接着する。次いで、このものをロ図のように波付け戸材2を内側にし（その裏面が上になつて表われる）、上記側縁とは反対側の側縁にシール用の接着剤3を塗布ガスにより充填的に施す一方、

波の谷部の稜線上には山部と同じ間隔で速乾性の接着剤 4 をのり付けロールでスポット的に塗布しながら、一端の閉じたセンターバイブ 5 の周りにうず巻き状に巻き付ける。

このようにして、一端縁がシール用接着剤 3 で閉じられ他端縁が開放された幅方向の多数の通路が形成され、かつ平板材 1 と波付け戸材 2 の表面同志または裏面同志が波の稜線のところで接着された戸過エレメント e が作られる。

しかし、この戸過エレメント e は使用時に上部になる一端縁に鉄板製の補強リング 6 が施されると共に下部になる他端縁には補強リング 6 と弾性バッキング 7 が施されて、コップ状の容器 a に収容され、その上にカバー b が被嵌され、容器 a とカバー b との周縁を複数のクリップ部材 c で緊締して用いられる。

(考案の解決しようとする問題点)

上記のように戸過エレメントの要素をなす平板戸材 1 と波付け戸材 2 は、製作上その表面同



志および裏面同志が波付け戸材2の波の山部または谷部の稜線に沿つて一定間隔にスポット接着されるが、従来の戸過エレメントではその接着間隔が50mm～60mmと比較的に大きいために、戸過エレメントとしての坐屈強度が充分でなく、エレメントを容器a内に収容しカバーbを施して両者の周縁部をクリップcで緊締すると、周囲部の戸材が圧迫によつて中央が側方にふくらむように変形し、接着部が剥がれて戸過機能を低下させてしまう。

一方、戸過エレメントの強度を増すために両戸材1、2の接着部分をやたらに多くすると、戸材の有効戸過面積が減少してエレメントの寿命が短くなつてしまう。

そこで、この考案は平板戸材と波付け戸材との表裏両面を適切な位置間隔で接着し、高い坐屈強度を備えかつ寿命の永い戸過エレメントを提供するものである。

(問題点を解決するための手段)

上記目的のもとにこの考案は、平板戸材と波

付け戸材からなつてセンターバイプ上にうず巻き状に巻回され、両戸材の表面同志は波付け戸材の一側側縁に施されたシール用の接着剤と波の各山部の稜線上の複数箇所に塗布された接着剤によつて接着され、また、裏面同志は波付け戸材の他側側縁に施されたシール用の接着剤と波の各谷部の稜線上の複数箇所に塗布された接着剤によつて一体に接合されるハニカム形の戸過エレメントとして、上記両戸材の表面および裏面における波の山部または谷部の稜線上の接着位置の間隔を20mmないし30mmにしたことの特徴とするものである。

(実施例)

第1図、第2図はこの考案の実施例を示すものであり、帯状の平板戸材11と波付け戸材12が向き合され、波付け戸材12の表面(向き合う面)の片側側縁にシール用の接着剤13が塗布ガンにより充填的に施され、それと同時に波の各山部の稜線上でシール部を除く部分に20mm～30mmの間隔で速乾性の接着剤14がの

り付けロールによつてスポット的に塗布され、平面戸材11と波付けロール12はシール用の接着剤13と波山稜線上の接着剤14によつて一体的に接着されている。

そして、この一体化されたものの波付け戸材12の裏面には、第2図のように表面接着側縁と反対側の側縁にシール用の接着剤13が充填的に施されかつ波の各谷部の稜線上でシール部を除く部分に20mm～30mmの間隔で速乾性の接着剤14がスポット的に塗布され、その一体化戸材は波付け戸材12を内側にして両端または一端が閉じられたセンターバイブ15の周りにうず巻き状に巻き付けられ、平板戸材11と波付け戸材12の裏面同志もシール用接着剤13と谷部稜線上の接着剤14によつて一体に接着された所要直径のロール状の戸過エレメントeに形成されている。

そして、この戸過エレメントeは前記のように一端縁に補強リングが取付けられ、他端縁には補強リングと弾性バッキンが施されてコツ

ア状の容器に収容されて使用される。

第3図は平板戸材11と波付け戸材12の表面および裏面における速乾性接着剤14による接着位置の間隔と、エレメントとしての坐屈強度および寿命との関係をぐらふにしたもので、A曲線は坐屈強度を、B曲線は寿命を表わすが、先ず、エレメントの坐屈強度についてみれば、接着位置の間隔と強度は逆比例しており、50mm以下の間隔になると直線的に強度が増し、30mmでは120kgで従来の50mm間隔の60kgに比べ2倍の強度となり、また、20mm間隔では165kgで50mm間隔の強度に対し2.7倍の強度を保有する。

一方、エレメントの寿命についてみれば、間隔0から20mmの間では間隔の増加につれて急激に増加し、20mmから50mmの間ではゆるやかなカーブを描いて上昇し、間隔50mm以上ではエレメントの寿命は殆んど変わらないことを示している。

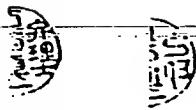
これらの事実からして、平板戸材11と波付

け戸材1 2との接着間隔の最適値は20mm～30mmといふことができる。

したがつて、本考案では平板戸材1 1と波付け戸材1 2の表裏両面における接着位置の間隔を20mm～30mmに選択するものである。

（考案の効果）

上述のようにこの考案では、平板戸材と波付け戸材からなつてセンターバイブ上にうず巻き状に巻回され、両戸材の表面同志は波付け戸材の一側側縁に施されたシール用の接着剤と波の各山部の稜線上の複数箇所に塗布された接着剤によつて接着され、また、裏面同志は波付け戸材の他側側縁に施されたシール用接着剤と波の各谷部の稜線上の複数箇所に塗布された接着剤によつて一体に接合されるハニカム形の戸過エレメントとして、両戸材の表面および裏面における波の山部または谷部の稜線上の接着位置の間隔を20mmないし30mmにしたので、戸過エレメントは従来のものに比べて2倍ないし3倍程度の大きな坐屈強度を持ち、エレメントを容



器に収納しカバーを施してクリップ部材で緊結にしたにしても、エレメントは中太りに変形せず、接着部が剥離することなく、戻過機能を低下させずに長い寿命を維持することができ、この種の戻過エレメントとして最適なものである。

4. 図面の簡単な説明

第1図はこの考案に係るエレメントの平板戻材と波付け戻材の接着状態を示す斜視図。

第2図は戻材をロール状に巻く状態の斜視図。

第3図は試験の結果のぐらふ。

第4図イは従来品の平板戻材と波付け戻材の接着状態を示す斜視図。

同図ロは従来品の戻材を巻く状態の斜視図。

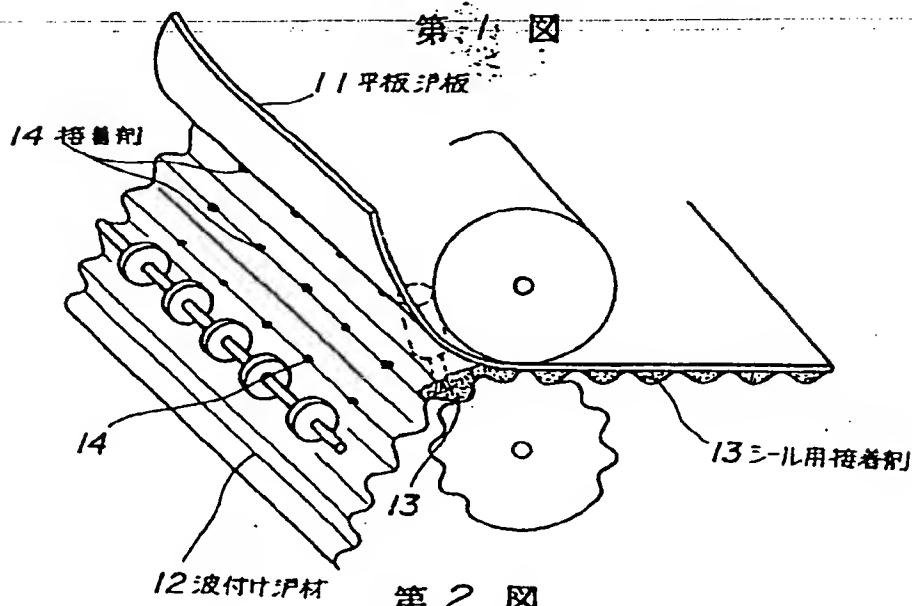
第5図はエレメントを容器に収納した状態の断面図。

図中、

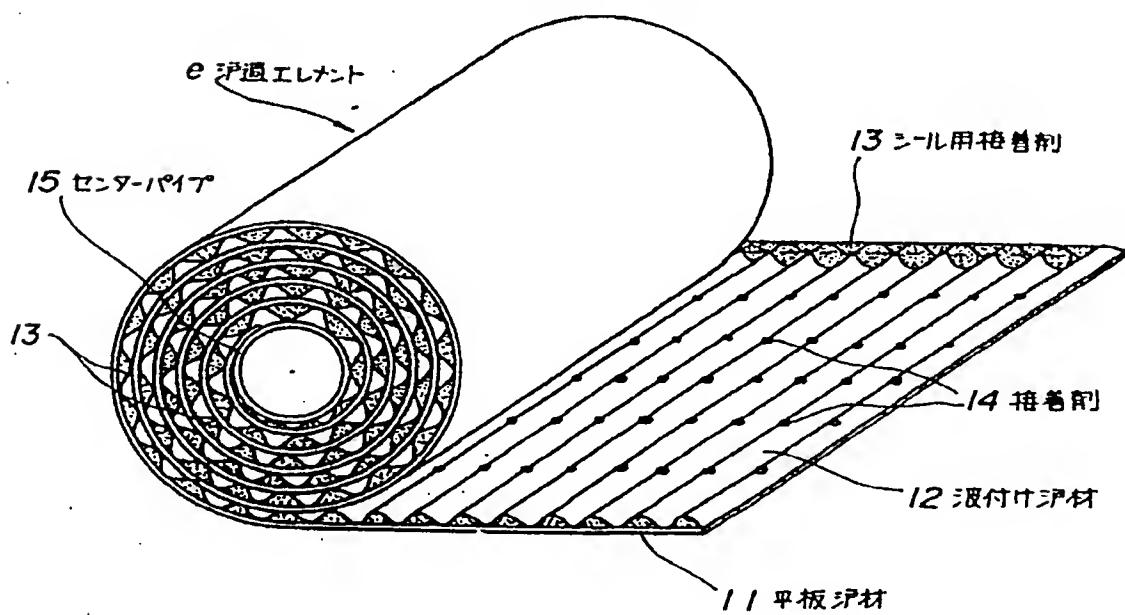
- 1、11……平板戻材
- 2、12……波付け戻材
- 3、13……シール用接着剤
- 4、14……接着剤
- 5、15……センターパイプ
- e…………戻過エレメント

公開実用 昭和63- 122617

第1図



第2図

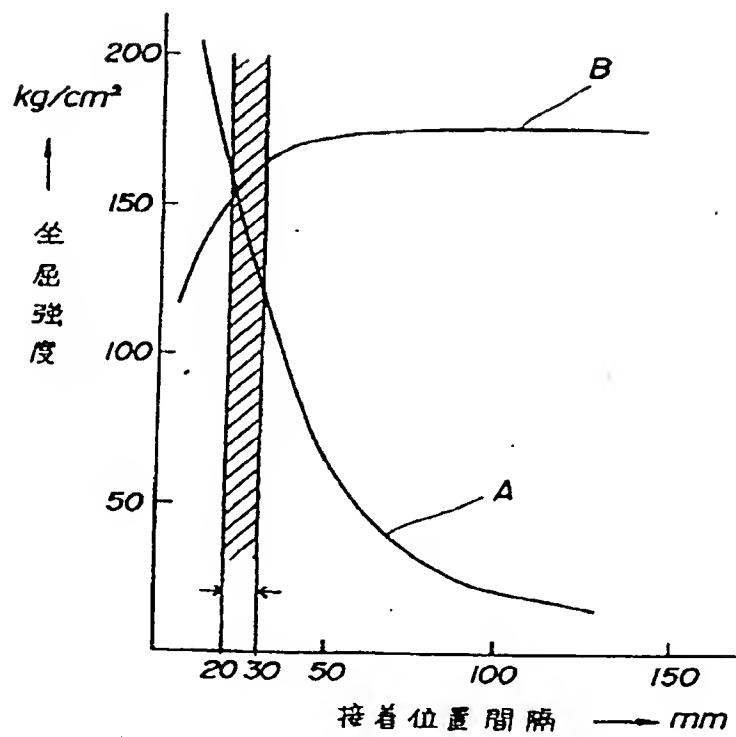


実用新案登録出願人 株式会社 土屋製作所

代理人 真田 真一

178.
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第3図



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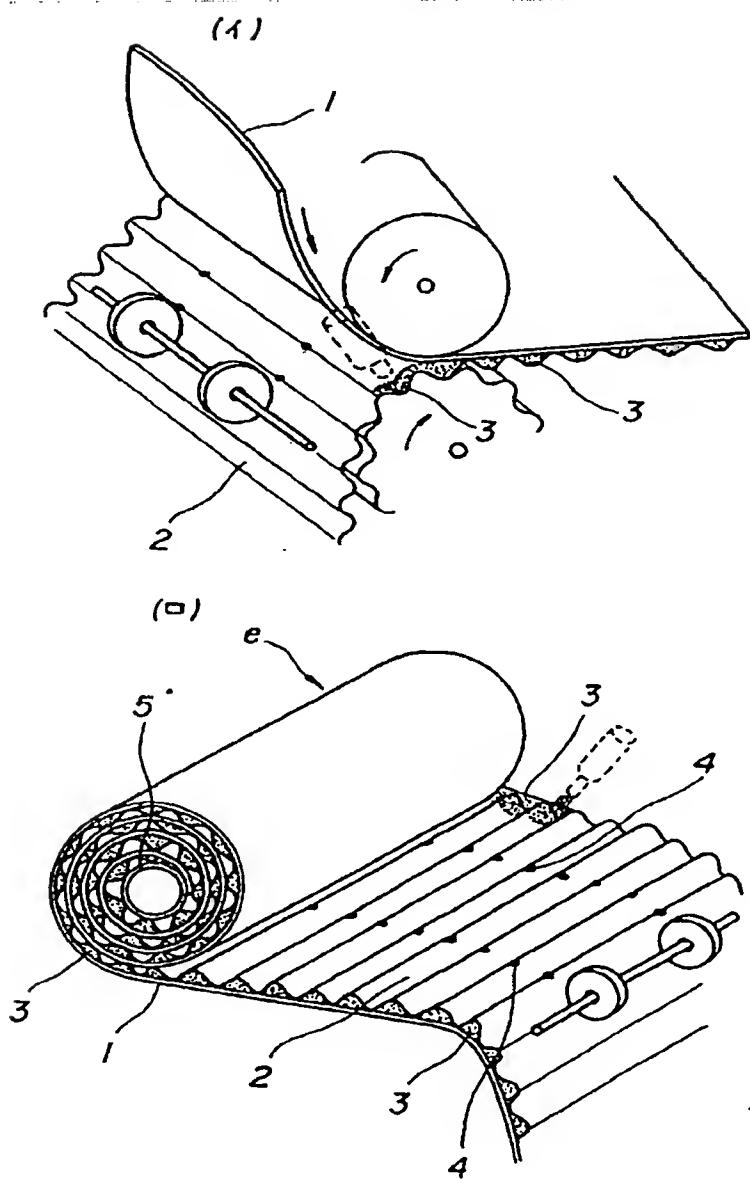
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第4図



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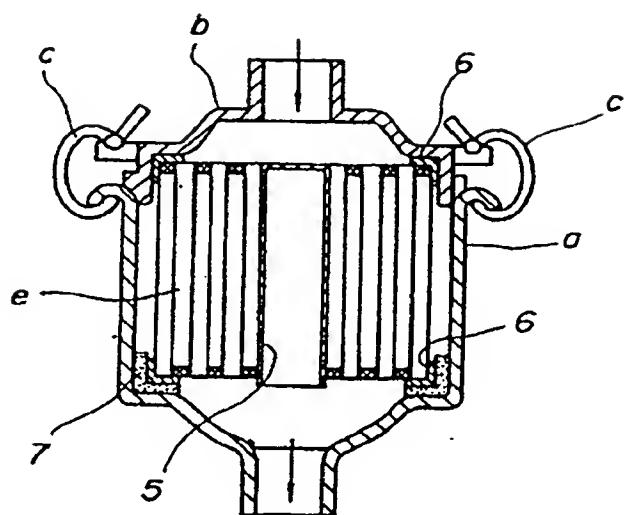
代理人

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第5図



实用新案登録出願人 株式会社 土星製作所

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